

Work Order ID 111156

January-09-14 12:35:27 PM

111156

Rev E 8/14/01/24

PRELIMINARY ISSUED
Page 1

Item ID: D4634-143

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Middle, Center Ceiling Replacement Panel Assembly

Stop

NS2

Start Date: 09/01/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

MP/MCS

Date: 14-01-09

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

DAS
27
9.89

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4634

PD2

PET

Rev E per ECN 14.509

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

① SAP 14/01/20

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D4634-143

Scotch weld 1300L M127913

② SAP 14/01/20

1- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # M127913

Expiry Date 07/10/2024

2- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

M1247235

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
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| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|
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Page 2

Item ID: D4634-143

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 09/01/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 24/01/2014 Req'd Qty: 1.00 ***1***

Customer:

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Process Plan:

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Tooling:

Date:

Run

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Date:

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Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

DAS
27
9-89

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

POSITIVE RECALL
EFFECTIVE 14-01-22 AUTH u

RELEASED

Release Dwg
Rev E 14/1/23

DAS
27
9-89

DATE 14/01/22

POSITIVE RECALL

EFFECTIVE 14-01-22 AUTH u

RELEASED

DATE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

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|--|--|---|--|

Picklist Print

January-09-14 12:35:31 PM

Page 1

Work Order ID: 111156

111156

Parent Item: D4634-143

D4634-143

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 09/01/2014

Required Date: 24/01/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 13/02/05 DL VERIFIED BY:JLM IPP Rev.
B Dwg. Update 13/07/09 DL verf: DD IPP Rev. C Dwg
Update remove channels add foam 13/12/23 DL

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D4647-1 *D4647-1* Doubler | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST116 | | | 8 | | | | | | |
| | | | | | 104796 | | 6 | | | | | | |
| | | | | | 95871 | | 2 | BW1234 | | | | | |
| D5021-3 *D5021-3* Foam, Center Panel, Middle | | Manufactured | No | | | 100 | Each | 0.0000 | 16 | 17* | | | |
| | | | | | | | | B111351 | ** | | | | |
| D4634-3 *D4634-3* Middle, Center Ceiling Panel | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 1 | | | |
| | | | | | | | | B110392 | ** | | | | |
| D4636-5 *D4636-5* Bracket | | Manufactured | No | | | 100 | Each | 1.0000 | 1 | 1 | | | |
| | | | | | | | | | ** | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST115 | | | 1 | | | | | | |
| | | | | | 110407 | | 1 | | | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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Picklist Print

January-09-14 12:35:31 PM

Page 2

Work Order ID: 111156

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Parent Item: D4634-143

D4634-143

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 09/01/2014

Required Date: 24/01/2014

Start Qty: 1.00

Required Qty: 1.00

D4664-5

Manufactured No

100

Each

94.0000

6

6

D4664-5

Spacer

**

SAD 14/01/17

Location

Loc Qty

Loc Code

ST118

94

103666

2

104793

36

110416

56

B111711

2.0000

1

**

2 ok
SAD 14/01/17

D4712-1

Manufactured No

100

Each

D4712-1

Bracket

Location

Loc Qty

Loc Code

prelim

2

110411

2

B111162

6.0000

1

**

(2)

SAD 14/01/17

D4732-21

Manufactured No

100

Each

D4732-21

Label

Location

Loc Qty

Loc Code

ST122

6

93173

6

9.0000

1

**

(1)

SAD 14/01/17

D4732-25

Manufactured No

100

Each

D4732-25

Label

Location

Loc Qty

Loc Code

ST122

9

93234

9

(1)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

January-09-14 12:35:31 PM

Page 3

Work Order ID: 111156

111156

Parent Item: D4634-143

D4634-143

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 09/01/2014

Required Date: 24/01/2014

Start Qty: 1.00

Required Qty: 1.00

MPNY-750S-9-C Purchased No

100 Each 9.0000 3 3

MPNY-750S-9-C

Mounting Pad

**

SAD 14/01/17

Location

Loc Qty

Loc Code

ST390

9

124058

9

127960

(3)

MS20426AD3-3 Purchased No

100 Each 2,846.000 4 4

MS20426AD3-3

RIVET

**

SAD 14/01/17

Location

Loc Qty

Loc Code

ST334

2846

123352

2846

m125578

4

MS20426AD4-5 Purchased No

100 Each 1,744.000 2 2

MS20426AD4-5

RIVET

**

SAD 14/01/17

Location

Loc Qty

Loc Code

ST334

1744

6874

744

m125807

1000

m124392

(4)

MS21059L3 Purchased No

100 Each 188.0000 2 2

MS21059L3

Nut Plate

**

SAD 14/01/17

Location

Loc Qty

Loc Code

ST316

188

M127743

188

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

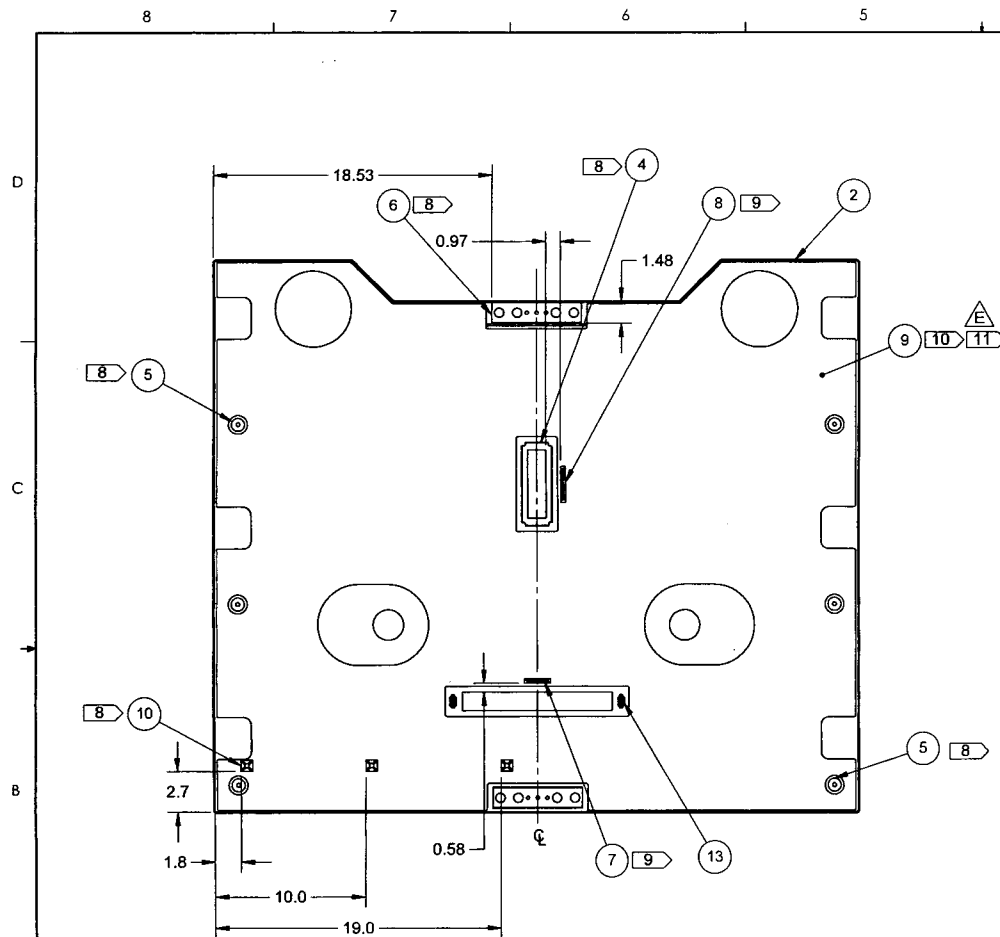
Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

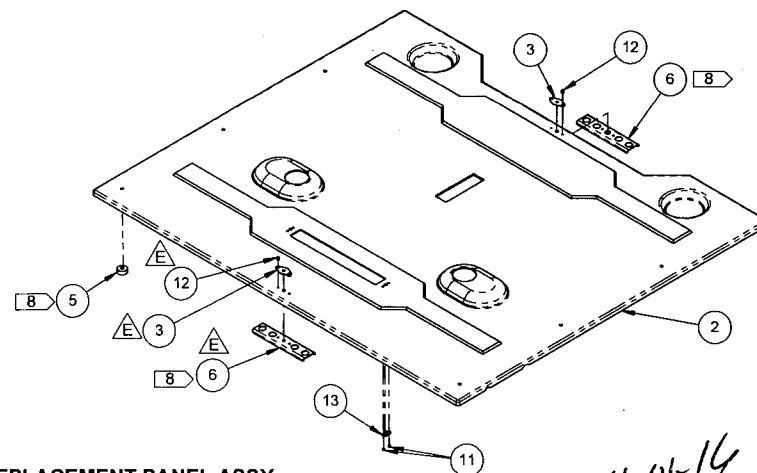


D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

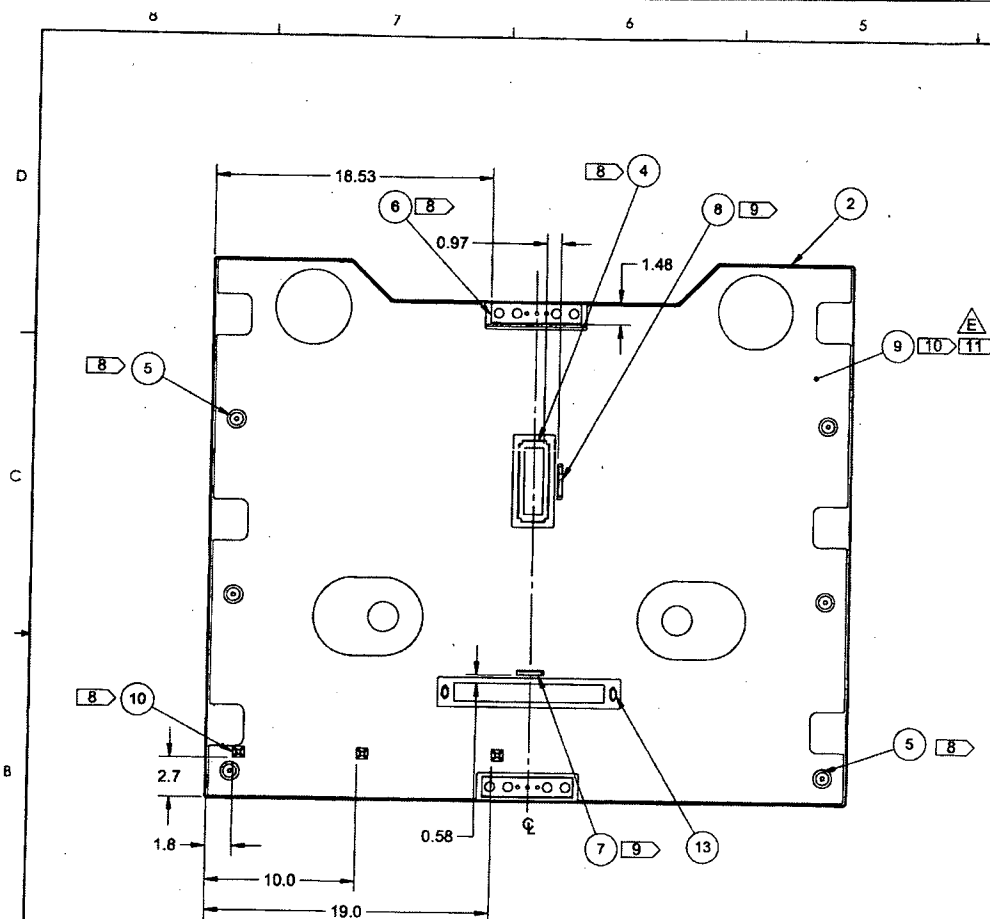
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.24 lbs
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1, D4664-5 & MPNY-750S-9C.
WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO D5021-3 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-3 FOAM ON D4634-3

| ITEM NO. | QTY. -143 | PART NUMBER | DESCRIPTION |
|----------|--------------|----------------|---|
| 1 | X | D4634-143 | MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY |
| 2 | 1 | D4634-3 | MIDDLE, CENTER CEILING PANEL |
| 3 | 2 | D4636-5 | BRACKET |
| 4 | 1 | D4647-1 | DOUBLER |
| 5 | 6 | D4664-5 | SPACER |
| 6 | 2 | D4712-1 | BRACKET |
| 7 | 1 | D4732-21 | LABEL |
| 8 | 1 | D4732-25 | LABEL |
| 9 | 1 | D5021-3 | FOAM, CENTER PANEL, MIDDLE |
| 10 | 3 | MPNY-750S-9-C | MOUNTING PAD |
| 11 | 4 | MS20426AD3-(4) | RIVET |
| 12 | 4 | MS20426AD4-(6) | RIVET |
| 13 | 2 | MS21059L08 | ANCHOR NUT |



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14-01-14

| | | | |
|------------|----------|---|---------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | DC | DRAWING NO. D4634 | REV. PE1 |
| MFG. APPR. | | TITLE | SHEET 8 OF 17 |
| APPROVED | | CENTER CEILING PANELS | |
| DE APPR. | | NTS | |
| DATE | 14.01.09 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

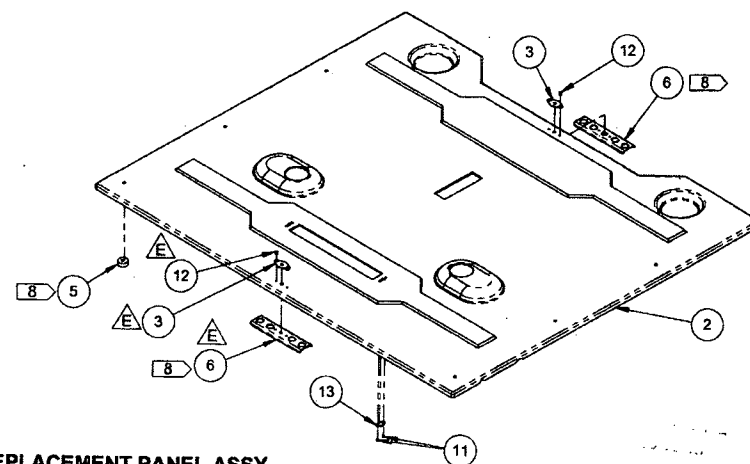


D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1, D4664-5 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN. SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-3 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-3 FOAM ON D4634-3

| ITEM NO. | QTY. -143 | PART NUMBER | DESCRIPTION |
|----------|--------------|----------------|---|
| 1 | X | D4634-143 | MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY |
| 2 | 1 | D4634-3 | MIDDLE, CENTER CEILING PANEL |
| 3 | 2 | D4638-5 | BRACKET |
| 4 | 1 | D4647-1 | DOUBLER |
| 5 | 6 | D4664-5 | SPACER |
| 6 | 2 | D4712-1 | BRACKET |
| 7 | 1 | D4732-21 | LABEL |
| 8 | 1 | D4732-25 | LABEL |
| 9 | 1 | D5021-3 | FOAM, CENTER PANEL, MIDDLE |
| 10 | 3 | MPNY-750S-9-C | MOUNTING PAD |
| 11 | 4 | MS20426AD3-(4) | RIVET |
| 12 | 4 | MS20426AD4-(6) | RIVET |
| 13 | 2 | MS21059L08 | ANCHOR NUT |



| | | | |
|------------|----------|---|---------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | DC | DRAWING NO. | REV. E |
| MFG. APPR. | DC | D4634 | SHEET 8 OF 17 |
| APPROVED | DC | TITLE | SCALE |
| DE APPR. | DC | CENTER CEILING PANELS | NTS |
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